

Date: Tuesday, 03/03/2009 1:02:23 PM
 User: Linda Lacelle

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	PAX SPEAKER MOUNT
Job Number :	46242		
Estimate Number :	10804		
P.O. Number :		Part Number :	D412785003403
This Issue :	03/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D412-785-003-403
First Issue :	/ /	Project Number :	
Previous Run :	46236	Drawing Revision :	
	Type :	Material :	
	SMALL /MED FAB	Due Date :	10/03/2009
Written By :		Qty:	14
Checked & Approved By :		Um:	Each
Comment :			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

CUT PER DRWG D412-785-003-403 REV.A HB 9-3-7

2.0	M2024T3S040	2024-T3 .040 sheet
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MAT NOT PULLED 106747 x 11



Comment: Qty.: 0.0580 sf(s)/Unit Total : 0.8120 sf(s) 107461 x 11

6061-T6 Sheet 0.032" .040 HB 9-3-7 DEBUR HB 9-3-7

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 9-3-7

22



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



05-03-12 22



Comment: SECOND CHECK

See attached

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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MB



Comment: HAND FINISHING RESOURCE #1

09-03-11

22

ACID ETCH AND ALODINE PER QSI005

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N

01.05.11

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: PAX SPEAKER MOUNT

Job Number: 46242

Part Number: D412785003403

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ID AND STK

PUT ASIDE TO SEND TO EAGLE

DS 09/03/12 (22)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

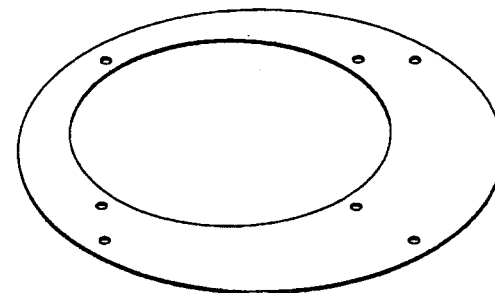
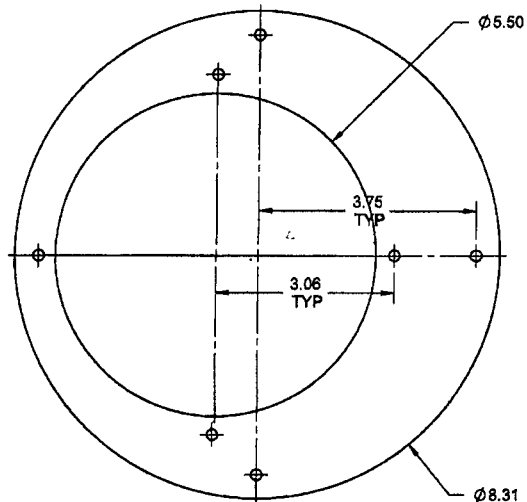
09/03/12 H

Job Completion



u 09.03.12

DONE



46242



D412-785-003-403 PAX SPEAKER MOUNT FWD



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/4 OR AMS 4037
- 2) FINISH: ALODINE AND PAINT PER CUSTOMER REQUIREMENTS
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

A NEW ISSUE		08.12.04	
REV	DESCRIPTION		BY DATE
DESIGN	RN	EAGLE COPTERS MAINTENANCE	
DRAWN	ES	CALGARY, ALBERTA, CANADA	
CHECKED	DA	DRAWING NO.	REV. A
MFG. APPR.	N/A	D412-785-003-403	SHEET 1 OF 1
APPROVED	CS	TITLE	SCALE
DE APPR.	N/A	PAX SPEAKER MOUNT	1:2
DATE	08.12.04		
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D 412 785 003 403

☒ **First Article** ☐ **Prototype**

Measured by: IB	Audited by: 	Prototype Approval: 
Date: 9-3-7	Date: 10-13-22	Date: N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD

Duplicate

Dart Aerospace Ltd.

Date: Tuesday, 10/03/2009 2:22:34 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : PAX SPEAKER MOUNT
Job Number : 46242	
Estimate Number : 10804	
P.O. Number :	Part Number : D412785003403
This Issue : 10/03/2009 S.O. No. :	Drawing Number : D412-785-003-403
Prsht Rev. : NC	Project Number :
First Issue : 03/03/2009 Type : SMALL /MED FAB	Drawing Revision :
Previous Run : 46236	Material :
Written By :	Due Date : 10/03/2009 Qty: 14 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

CUT PER DRWG D412-785-003-403 REV.A

MM 09 03 07 (14)

2.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



107461



Comment: Qty.: 0.0580 sf(s)/Unit Total: 0.8120 sf(s)
6061-T6 Sheet 0.032"

MM 09 03 07 (14)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MM 09 03 07 (14)

4.0	QC8	SECOND CHECK
-----	-----	--------------



09-03-12 (22)



Comment: SECOND CHECK

See duplicate attached

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

ACID ETCH AND ALODINE PER QSI005

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Date: Tuesday, 10/03/2009 2:22:34 PM
User: Linda Lacelle

Process Sheet *Duplicate*

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: PAX SPEAKER MOUNT

Job Number: 46242

Part Number: D412785003403

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
ID AND STK
PUT ASIDE TO SEND TO EAGLE

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



L Lacelle

From: Kelly Labas [klabas@eaglecopters.com]
Sent: March 12, 2009 1:54 PM
To: 'L Lacelle'
Subject: RE: hawker parts

All good, Thanks

KL

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Thursday, March 12, 2009 11:43 AM
To: 'Kelly Labas'; 'Harvey Siemens'
Subject: RE: hawker parts

I'm shipping everything that I have, there will be 2 of these on b/o.
Also....2 parts were made with 6061T6, instead of 2024T3 – D412-785-003-401 and D412-785-004-403F...are these acceptable?
Also...some parts we made 1 or 2 extra, I am sending you these as well, just leave your P.o as is.
LL

From: Kelly Labas [mailto:klabas@eaglecopters.com]
Sent: March 12, 2009 1:32 PM
To: 'L Lacelle'; 'Harvey Siemens'
Subject: RE: hawker parts

Six is what I need, the seventh is back up. But it does have to be 6061-T6. How long to get more material? Can you send me as many as you have?

KL

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Thursday, March 12, 2009 10:51 AM
To: 'Kelly Labas'; 'Harvey Siemens'
Subject: RE: hawker parts
Importance: High

Do not have enough mat'l to make 7, can we use another mat'l, 2024?
LL

From: Kelly Labas [mailto:klabas@eaglecopters.com]
Sent: March 12, 2009 9:09 AM
To: 'L Lacelle'; 'Harvey Siemens'
Subject: RE: hawker parts

Hi Linda,

No, please leave undrilled. Those holes will be transfered by the installer.

12/03/2009

KL

From: L Lacelle [mailto:llacelle@dartaero.com]

Sent: Thursday, March 12, 2009 5:01 AM

To: 'Harvey Siemens'

Cc: 'Kelly Labas'

Subject: hawker parts

Importance: High

Hi again,

On D412-785-004-401F, there are 4 extra holes from your dxfs that are NOT on the drwg, are these good?

Please see attached

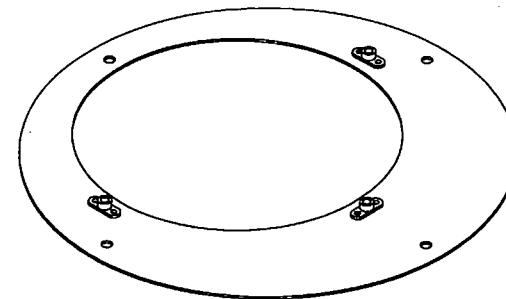
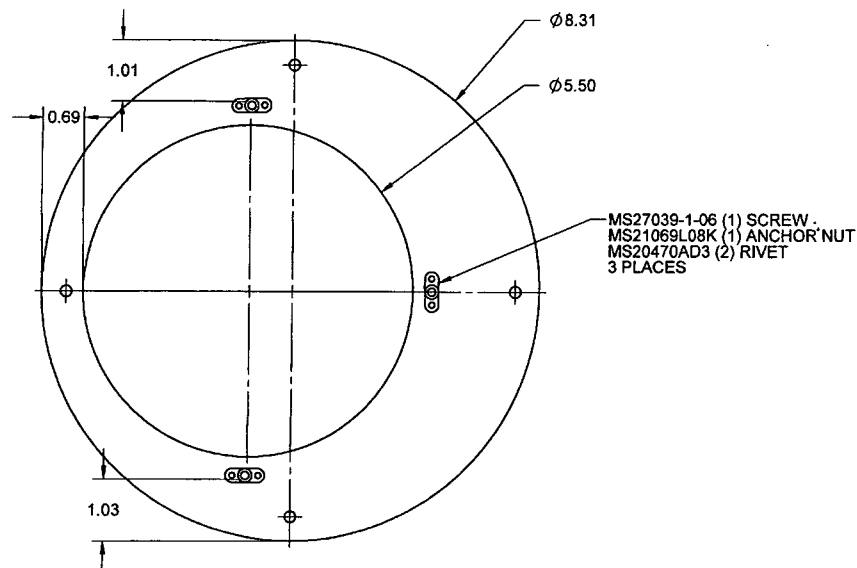
Thank You,

Linda Lacelle

Production Manager

Dart Aerospace Ltd

12/03/2009



D412-785-003-203 PAX SPEAKER MOUNT FWD

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) UNITS: INCHES UNLESS OTHERWISE NOTED
4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
5) IDENTIFICATION: N/A
6) WEIGHT: 0.04 lbs

A NEW ISSUE		08.12.04	
REV		DESCRIPTION	BY DATE
DESIGN	RN	EAGLE COPTERS MAINTENANCE	
DRAWN		CALGARY, ALBERTA, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	D412-785-003-203	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.	N/A	PAX SPEAKER MOUNT	NTS
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Date: Tuesday, 10/03/2009 2:22:19 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 46242	Customer	: Dart Aerospace Ltd.
Estimate Number	: 10804	DWG Name	: PAX SPEAKER MOUNT
Purchase Order #	:	Part Number	: D412785003403
Complete Date	: / / : : AM	DWG Number	: D412-785-003-403
Rev.	:		

DUE DATE	ORDERED	DELIVERED
10/03/2009	14	0

1.0 WATER JET	Internal Operation
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DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
07/03/2009	BLEC01: Bleck, Henry	Run	22.000	0.46	\$7.75	0.47	19.25
Subtotal:			QTD: 22	CTD: 0	0.46	\$27.00	

2.0 M2024T3S040-2024-T3 .040 sheet	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty	COST
07/03/2009	BLEC01: Bleck, Henry	M2024T3S040	0.000	\$0.00
Subtotal:			QTD: 0	CTD: 0
				\$0.00

	TIME	COST
Machine Time:	0.47	\$19.25
Labor:	0.46	\$7.75
Sub-contract (external Op.):		\$0.00
INVENTORY ITEM:		\$0.00
SUB-COMPONENT (SUB-JOB):		\$0.00
Total:		\$27.00

COST PER UNIT:	\$27.00
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